



Dart Aerospace Ltd.
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D4017-041
Job Sheet 195347



Part No: D4017-041

Job Qty: 1 pcs

Part Name: Short Basket Base Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/17/19

Job Tracking No:

Due Date: 5/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D4017 REV F SHEETS 1,2,3,4 IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD ver:EC IPP REV:F 12.07.24 AS PER DWG REV.D DD VERF:EC IPP REV:G 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	5/31/19		0.00	14.93	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	QC 9	1 pcs	5/31/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
120	QC 5	1 pcs	5/31/19		0.00	0.00	QC 9 - 50		
							QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



Container No: S191315



Part: D4017-041

Job No: 195347

Serial No/Batch: S191315

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/18/19

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						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
125 Handfinish - 2-1 Pressure-B4B	1 pcs	5/31/19	0.00	0.40		Handfinish - 2 - 1 - B4B	
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	3619-6-01
						Handfinish - 2 - 4 - B4B	
130 Powdercoat - 2 White GI(S)-B4B	1 pcs	5/31/19	0.00	0.68		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	3619-6-01
						Powdercoat - 4 - B4B	
140 QC 3	1 pcs	5/31/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	14-6-21
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
150 Handfinish - 4-1-Assembly-B4B	1 pcs	5/31/19	0.00	0.40		Handfinish - 4 - 1 - B4B	14-6-21
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	

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160 QC 5	1 pcs	5/31/19	0.00 0.00	Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
170 Packaging 3-1 - Stock - B4B	1 pcs	5/31/19	0.00 0.00	QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1	5/31/19	0.00 0.00	QC 21 - SA - 21	

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pcs	QC 21 - SA - 70
	QC 21 - SA - 53

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: _____), 1- assemble ribs , weld as per dwg D4017 using DT9610B 2- Cut
Descriptions: mesh as per dwg D4020-3 3- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary and trim to
clear fasteners holes on the ends 4- weld hinge (3) and Mounting brackets as per dwg D4017 5- Weld D4672-3 blanking
plates as per dwg
110 - (QC9- Inspect visual per QSI004- Fusion Welds)
120 - (QC5- Inspect part completeness to step on W/O)
125 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)
130 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel), 1- Plug holes and mask only interior of hinge (3) prior to powder
coat
140 - (QC3- Inspect Part Finish)
150 - (Assemble as per dwg)
160 - (QC5- Inspect part completeness to step on W/O)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

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Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5188852
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5189576
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	5183955
D3916-5	Light Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5179611
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	5121276
D4017-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5179195
D4017-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5179721
D4017-5	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5158234
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5173533
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5180771
D4020-1	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5186358
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	5179504
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5181473
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5181719
D4672-3	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5107830
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5181090
AN3-10A	Bolt	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5179612-1
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5170069
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5155667
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5157402-1
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5034411-1
NAS1149DN832J	Washer	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5155921
NAS1149F0332P	Washer	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	26	0
	D3913-15	1	5	0
	D3916-041	2	13	0
	D3916-5	1	19	0
	D4016-1	3	33	0
	D4017-1	1	5	0
	D4017-3	1	5	0
	D4017-5	1	8	0
	D4017-7	3	55	0
	D4017-9	2	20	0
	D4020-11	2	12	0
	D4021-1	3	33	0
	D4034-041	1	9	0
	D4034-043	1	9	0
	D4672-3	2	3	0
	M304EX0.75-16F	32	608	0
	AN3-10A	6	345	0
	D2931	2	723	0
	D4021-5	2	22	0
	MS20600-AD4W3	2	364	0
150-Handfinish - 4-1-Assembly-B4B	MS21042L3	6	2,689	0
	NAS1149DN832J	2	365	0
	NAS1149F0332P	12	4,467	0
Part Specifications				
Specifications could not be found.				

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NCR No. _____													
Job: _____ Part No. _____		DISPOSITION				DEPARTMENT/PROCESS							
		Rework Scrap Use-as-is				Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality	
Date :		Sequence #:		QTY Affected :		MRB (QS1042)							
Description Work Order Deviation						Disposition							
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors						FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread							
Completed By						Lead hand / Supervisor						QC / QA Coordinator	